

*A* *I* Claims

- 5 1. Door internal element (3) for motor vehicle doors  
(1), to be arranged between a door outer side and  
an inner lining (7), characterized in that, during  
production using the foam injection process, a  
sealing body (12) is disposed at the edge.
- 10 2. Door internal element according to Claim 1 or in  
particular according thereto, characterized in  
that cable holders (17) are moulded onto the door  
internal element (3).
- 15 3. Door internal element according to one or more of  
the preceding claims or in particular according  
thereto, characterized in that a mounting collar  
(31) for holding a loudspeaker (32) is moulded on.
- 20 4. Door internal element according to one or more of  
the preceding claims or in particular according  
thereto, characterized in that a cable bushing  
(21) is moulded out.
- 25 5. Door internal element according to one or more of  
the preceding claims or in particular according  
thereto, characterized in that the cable bushing  
(21) has an edging (24) made from soft plastics.
- 30 6. Door internal element according to one or more of  
the preceding claims or in particular according  
thereto, characterized in that the door internal  
element (3) has a moulded-in bush (26).
- 35 7. Door internal element according to one or more of  
the preceding claims or in particular according  
thereto, characterized in that the door internal

element (3) has an inserted support plate (36) for mounting a motor (37).

- 5 8. Door internal element according to one or more of the preceding claims or in particular according thereto, characterized in that the support plate (36) is a metal plate.
- 10 9. Door internal element according to one or more of the preceding claims or in particular according thereto, characterized in that the door internal element (3) has bridges (45) which are moulded out by injection-moulding techniques and the underside (46) of which is exposed.
- 15 10. Door internal element according to one or more of the preceding claims or in particular according thereto, characterized by a partial wall offset (49) in the door internal element (3) as a laying path for a strip-like insert (51).
- 20 11. Door internal element according to one or more of the preceding claims or in particular according thereto, characterized in that the sealing body (12) is formed as a bead which is applied to a wide face (55) of the door internal element (3).
- 25 12. Door internal element according to one or more of the preceding claims or in particular according thereto, characterized in that the sealing body (12) is located in an integrally formed groove (57).
- 30 13. Door internal element according to one or more of the preceding claims or in particular according thereto, characterized in that the groove (57) is formed by means of a wall offset so as to mould
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out a foam injection-formed bead (58) on the rear side, that is to say the other wide face (59).

14. Door internal element according to one or more of the preceding claims or in particular according thereto, characterized in that the density of the door internal element (3) varies over a cross section, that is to say is between 0.7 and 1.4 g/cm<sup>3</sup> in an unfoamed boundary layer (52) and is between 0.1 and 0.6 g/cm<sup>3</sup> in the foamed central layer (54).
15. Door internal element according to one or more of the preceding claims or in particular according thereto, characterized in that the foam injection-formed material contains a proportion of an HMS polymer.
16. Door internal element according to one or more of the preceding claims or in particular according thereto, characterized in that the foam injection-formed material contains fillers or reinforcing substances.
17. Door internal element according to one or more of the preceding claims or in particular according thereto, characterized in that anchoring apertures (60) are provided on the end face, which anchoring apertures have a solid hole lining (61) lying in the direction of the aperture as a result of integral moulding-out.
18. Door internal element according to one or more of the preceding claims or in particular according thereto, characterized in that an anchoring aperture (60) is surrounded by an integrally foamed tab section (62) which projects on the end face.

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19. Door internal element according to one or more of the preceding claims or in particular according thereto, characterized in that bushes, threaded inserts, etc. are incorporated in the door internal element (3) by injection moulding around them.
20. Door internal element according to one or more of the preceding claims or in particular according thereto, characterized in that some of the material is removed, or a cut which does not run all the way through is made, in the door internal element (3) on the wide face side, so as to provide access to the lower-density central layer (54).
21. Door internal element according to one or more of the preceding claims or in particular according thereto, characterized in that the exposed regions of the central layer (54) serve as access for anchoring means (54).
22. Door internal element according to one or more of the preceding claims or in particular according thereto, characterized in that clips (71) are secured in the door internal element (3), leaving an integral outer skin.

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